April: 16-13 12:35:42 PM Item ID: 646.4001 Accept *N900040100* Setup Start **Revision ID:** Item Name: AS350 Cable Cutter **Start Date:** 4/16/13 Start Qty: 1.00 *1* Cust Item ID: Required Date: 4/30/13 Reg'd Oty: 1.00 **Customer:** Reference: Run Approvals: Process Plan: Date: 13-04-16 Tooling: MLJ Date: QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. **Work Center ID** Description **Run Hours** Qty Code Qty Number Stamp **Draw Nbr Revision Nbr** 646.4000 Α 100 DOCUMENT CONTROL *100* Memo Document Control Photocopy bluefile & type labels per PPP 646.400 110 Pick Kit 0.00 *110* Packaging 0.00 Memo Packaging 120 QC4-100% Inspect kits for completeness *120* Memo

Work Order ID 99935

Quality Control

											DQA:	Date:	
NCR:	es /	/ No				WORK ORDER NON-O	100	NFORM	MANCE / UPI	DATE			
											QA Closed:	Date:	
Work Orde	ař.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
WORK OTHE	·' -					Rework	1		Skid-tube	Crosstube	1	Water Jet	Engineering
Part N	۱o. ٔ					Scrap			Machining Small Fab Prod. Eng. Coor.			Quality	
						Use-as-is		Thermoforming Finishing			Rec/Sto	re/Packaging	Other
NCR N	No					Work Order Update	J		Large Fab	Composite		Supplier	
Root					Descri	ption of work order update		Initial	Act	tion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling							ļ						
Operator	\Box												
Material	Ш												
Setup	Ш												
Other	Ш												
Process												!	
Supplier									·				
Training													
Unapproved											<u></u>		
						F	AUL	T CATE	GORY				
Landi	ng Ge	ar				General		-			•		7
~	В	ending				Bend		Grain		<u> </u>	Ovalized		Pressure/Forced
	Centre Not Concentric to O/S BOM/Route							Hardwa	re		Over/Under	tolerance	Temperature/Cure
		racks				Broken/Damaged	L	Inspecti	on Incomplete		Part Incorred	ct	Weld
	Crushed/Crimped Burrs							Instruct	ions Incomplete/l	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs Contamination							Mainte	nance	[Part Moved		
	Heat Treat Counters					Countersink		Mislabe	led		Positioned V	Vrong	_
	Inspection Strip in Tube					Cut Too Short	Г	Misread	1		Power Loss/	Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 99935

April-16-13 12:35:42 PM

99935

Item ID: 646.4001 Accept *N900040100* Setup Start Revision ID: Item Name: AS350 Cable Cutter **Start Date:** Start Qty: 1.00 4/16/13 **Cust Item ID:** Required Date: 4/30/13 **Reg'd Qty:** 1.00 **Customer:** Reference: Run Process Plan: **Approvals:** Date: **Tooling:** Date: Date: _____ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. Work Center ID Description **Run Hours** Code Qtv Qty Stamp Number 130 0.00 Packaging *130* Packaging Memo 0.00 Packaging Identify and pack for shipping as per PPP 646.4001 Location: 140 QC21- Final Inspection - Work Order Release 0.00 ML5 13-05-30 MF (3-5-30 QC 0.00 Memo Quality Control

NCR:	Yes	/	No
INCA.	162	,	INU

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Date:

NCR: Y	es / No				WORK ORDER NON-C	JUN	IFORI	VIAIVCE / OF	DAIL	QA Closed:	Date	::
Work Orde	··				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N					Rework Scrap			Skid-tube Machining	Crosstube Small Fab	-4	Water Jet d. Eng. Coor.	Engineering Quality
NCR N	0				Use-as-is Work Order Update		Thern	noforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
Root				Descri	ption of work order update	li	nitial	Ac	ction	Sign &	,	
Cause	Date	Step	Qty	(or Non-conformance	Chi	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data											A config	
Equip/Tooling												
Operator		ł										
Material		<u> </u>		*								
Setup		}									1	
Other												
Process												
Supplier		=	1									
Training												
Unapproved												
						AUL	T CATE	GORY				
Landin	ng Gear			_	General				_	.	_	-
	Bending				Bend		Grain			Ovalized	ļ_	Pressure/Forced
	Centre No	ot Concer	ntric to C)/S	BOM/Route		Hardwa		<u> </u>	Over/Under	_	Temperature/Cure
Ĺ	Cracks Broken/Damaged						! -	ion Incomplete	<u> </u>	Part Incorred	—	Weld
1	Crushed/Crimped Burrs					-		tions Incomplete/	'Unclear	Part Lost/Mi	issing	Wrong Stock Pulled
1	Cuffs Contamination					\vdash		enance		Part Moved		
ļ	Heat Treat Countersink						Mislabe		<u></u>	Positioned V		- 1
	Inspection Strip in Tube Cut Too Short					\vdash	Misread	d	L	Power Loss/	Surge	Other
	Ripples in Bend Drill Holes					Offset						
	Torque Waves in Extrusion Drawing					Out of Calibration						
	Turning Sequence Finish					Out of Sequence						
	Wave/Tw	ist in Tuk	oe -		Folio		Outside	e Dimensions				

April-16-13 12:35:46 PM

Work Order ID: 99935

99935

Parent Item:

646.4001

646 4001

Parent Item Name: AS350 Cable Cutter

Start Date: 4/16/13

Required Date: 4/30/13

Start Qty: 1.00

Required Qty: 1.00

Com	me	nte	
CUIII	1116	HILS.	

Comments:	IPP REV:A 12.10.	.23 NEW ISSUE	DD	VERF:JLM									
Component Item ID/ Item Name	Replacement Item ID	Purch	Bin Item	•	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
*646.3301 *646.3301 Upper Cutter Assembly	1 €	Manufactured	No				Each	25.0000	**	1	<i>(</i>		20
5	mP			Location ST139A ST545	125083	<u>Loc (</u>	Oty 7 7 18	Loc Code	_				, ⊸ ∤*
*646.3001	*	Manufactured	No	-	93247		18 Each	17.0000	**	54327)		\$0
5	mp			Location ST139A ST537	125083	<u>Loc Q</u>	<u>Oty</u> 9 9 8	Loc Code	_		,	(<i>y.</i> •
646.2910 *646.2910	<u>*</u>	Manufactured	No		93425		8 Each	6.0000	**	3428 1	122	6	Blobs

Location Loc Oty Loc Code ST139A 125083

									DQA:	Date:	
NCR: Y	es / No				WORK ORDER NON-C	ONFORM	MANCE / UF	PDATE	QA Closed:	Date:	
Work Orde	·				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No					Rework Scrap Use-as-is Work Order Update	Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	rall Fab Prod. Eng. C nishing Rec/Store/Packa		Engineering Quality Other
Root				Descri	ption of work order update	Initial		ction	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief Eng	Des	cription	Date	Verification	QC Inspector
Doc/Data											
quip/Tooling											
Operator											
Material						:					
otun -											

	PAULI CATEGORY											
Landing	g Gear	General										
	Bending	Bend		Grain		Ovalized		Pressure/Forced				
	Centre Not Concentric to O/S	BOM/Route		Hardware		Over/Under tolerance	L	Temperature/Cure				
	Cracks	Broken/Damaged		Inspection Incomplete		Part Incorrect	L	Weld				
	Crushed/Crimped	Burrs		Instructions Incomplete/Unclear	L	Part Lost/Missing	L	Wrong Stock Pulled				
· [Cuffs	Contamination		Maintenance		Part Moved						
	Heat Treat	Countersink		Mislabeled		Positioned Wrong	_	_				
. [Inspection Strip in Tube	Cut Too Short		Misread		Power Loss/Surge		Other				
	Ripples in Bend	Drill Holes		Offset								
	Torque Waves in Extrusion	Drawing		Out of Calibration								
	Turning Sequence	Finish		Out of Sequence								
	Wave/Twist in Tube	Folio		Outside Dimensions								

Other Process Supplier Training Unapproved

April-16-13 12:35:46 PM

Work Order ID: 39935

99935

Parent Item:

646.4001

646 4001

Parent Item Name: AS350 Cable Cutter

Start Date: 4/16/13

Required Date: 4/30/13

Start Qty: 1.00

Required Qty: 1.00

646.3810

Manufactured

Each 8.0000

Location ST139A

Loc Qty

Loc Code

14/00/30

646.3510

Manufactured

Manufactured

No

No

93300 8 Each

3.0000

Location ST139B

125083

125023

125083

Loc Qty 3 Loc Code

3

Each

Each

Each

2.0000

646.3511

Location ST

Loc Oty 2 2 Loc Code

1.0000

Manufactured

Manufactured

Location ST139A

Loc Oty

Loc Code

24.0000

Location ST139A

Loc Oty 24

Loc Code

April-16-13 12:35:46 PM

Shop Packet Print

Page 2

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UF	PDATE			
								_			QA Closed:	Date:	
Work Ord	or.					DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS	
Work Ord	٠٠٠.					Rework	٦		Skid-tube	Crosstube		Water Jet	Engineering
Part I	No.					Scrap	1	B	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
			·			Use-as-is	1		Thermoforming Finishing			re/Packaging	Other
NCR I	No.					Work Order Update			Large Fab	Composite	- 		
								<u> </u>	,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,				
Root			_		i e	ption of work order update		Initial		ction	Sign &	<u></u>	
Cause		Date	Step	Qty	•	or Non-conformance	Cr	nief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling]										
Operator							1						
Material	Ш			l I					, t				
Setup	Щ												
Other	Ш												
Process	Ш												
Supplier													
Training	<u> </u>												
Unapproved			L	<u> </u>	L	<u></u>						<u> </u>	
							AUI	LT CATE	GORY				
Landi	ng (I			_	General		1			l		1
	\vdash	Bending				Bend	<u> </u>	Grain			Ovalized		Pressure/Forced
	\vdash	Centre N	ot Concer	ntric to	o/s	BOM/Route	\vdash	Hardwa			Over/Under		Temperature/Cure
	igspace	Cracks			<u> </u>	Broken/Damaged	-	4 '	on Incomplete		Part Incorred		Weld
	Crushed/Crimped					Burrs	1	4	ions Incomplete,	/Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	$ldsymbol{ldsymbol{ldsymbol{eta}}}$	Cuffs				Contamination	\perp	Mainte		<u> </u>	Part Moved		
	$ldsymbol{ldsymbol{ldsymbol{ldsymbol{eta}}}$	Heat Trea	at			Countersink	Mislabeled				Positioned V	_	1
1		Inspectio	n Strip in	Tube	İ	Cut Too Short	1	Misread			Power Loss/	Surge	Other

Out of Calibration Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

April-16-13 12:35:46 PM

Work Order ID: 199935

Parent Item:

646.4001

Parent Item Name: AS350 Cable Cutter

99935 *646 4001*

Start Date: 4/16/13

Start Qty: 1.00

Required Date: 4/30/13

Required Qty: 1.00

NAS1149F0332P

WASHER

MS21042L3

Purchased

Purchased

No

No

8.710.000

4,780.000

**

Locatio	<u>n</u>	Loc Qty	Loc Code	
GA		182		
	122063	182		
ST294		158		
	122063	158		
ST295		3		
	123352	3		
st510		8367		
	123900	8367		12250

Each

Each

**

Nut

<u>Location</u>	Loc Oty	Loc Code
FP001	3	
122141	3	
GA	119	
122452	119	
ST314	268	
117885	32	
119017	55	
119075	138	
123265	43	
ST506	4390	

974

3416

123900

124291

											DQA	: Date	!
NCR: Y	'es	/ No				WORK ORDER NON-	COI	NFOR	MANCE / UP	DATE			
					-						QA Closed	: Date	•
Work Orde	r:					DISPOSITION				AGAINST D	EPARTMEN'	T/PROCESS	
Part N	-					Rework Scrap		i .	Skid-tube Machining	Crosstube Small Fab		Water Jet od. Eng. Coor.	Engineering Quality
NCR N	lo				 .	Use-as-is Work Order Update]	Therr	noforming Large Fab	Finishing Composite	Rec/Sto	ore/Packaging Supplier	Other
Root					Descri	ption of work order update		Initial	Ac	tion	Sign &		
Cause		Date	Step	Qty	·	or Non-conformance	Cr	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
	1_					F	AUL	T CATE	GORY		· · · · · · · · · · · · · · · · · · ·	1	
Landin	ng G	ear			-	General							
		Bending Centre No Cracks	ot Concer	ntric to (o/s	Bend BOM/Route Broken/Damaged		Grain Hardwa Inspect	ire ion Incomplete	F	Ovalized Over/Unde Part Incorre	 -	Pressure/Forced Temperature/Cure Weld

Instructions Incomplete/Unclear

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Wrong Stock Pulled

Other

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Part Moved

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Crushed/Crimped

Inspection Strip in Tube

Torque Waves in Extrusion

Cuffs

Heat Treat

Burrs

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

April-16-13 12:35:46 PM

Work Order ID: 399935

99935

Parent Item:

646,4001

646 4001

Parent Item Name: AS350 Cable Cutter

Start Date: 4/16/13 Start Qty: 1.00

Required Date: 4/30/13

Required Qty: 1.00

646.3110

Manufactured

Manufactured

Manufactured

Manufactured

Each 6.0000

Channel

646.3710

646.3713

Location ST139A

Loc Qtv

Loc Code

6

Each

22.0000

Location ST425

97175

125083

Loc Qty 22 22 Loc Code

Each

5

5

7

Each

5.0000



646.3210

Location ST538

Loc Oty 93488

Loc Code

7.0000

**

Location

ST139A

93208

Loc Qty

Loc Code

											DQA:	Date	N
NCR:	Yes /	No				WORK ORDER NON-O	100	VFORM	MANCE / UP	DATE	QA Closed:	Date	2:
NA/ a mla O mala						DISPOSITION				AGAINST DE		· · · · · · · · · · · · · · · · · · ·	
Work Orde		;				Rework Scrap]		Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality
NCR N						Use-as-is Work Order Update		Therm	noforming Large Fab	Finishing Composite	4	e/Packaging Supplier	Other
Root					Descri	ption of work order update		nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data						-							
Equip/Tooling	Н												
Operator	Н												
Material	Н						1						•
Setup	\vdash							•					
Other	Н												
Process Supplier	Н												
Training	Н		•										
Unapproved							١.						
опарргочеи	<u> </u>					. F.	AUL	T CATE	GORY			<u> </u>	
Landi	ng Gea	ır				General						·	
		ending				Bend		Grain			Ovalized		Pressure/Forced
	∏c∈	ntre No	t Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cr	acks				Broken/Damaged		Inspecti	on Incomplete		Part Incorred	t [Weld
	Crushed/Crimped Burrs					Burrs		Instruct	ions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs Contam					Contamination		Mainte	nance		Part Moved		
	Heat Treat Countersink							Mislabe	led		Positioned V	/rong	 -
	☐ In	spection	Strip in	Tube		Cut Too Short		Misread	1		Power Loss/	Surge	Other
	Ri	pples in	Bend			Drill Holes		Offset					
	Torque Waves in Extrusion Drawing					Drawing	Out of Calibration						

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

April-16-13 12:35:46 PM

Work Order ID: 99935

Parent Item:

MS24694-S51

646.4001

Parent Item Name: AS350 Cable Cutter

99935 *646 4001*

Start Date: 4/16/13

Start Qty: 1.00

Required Date: 4/30/13

Required Qty: 1.00

Screw

AN3-13A

Purchased

Purchased

Purchased

No

No

Each 108.0000

No

ST303

Location

116805 123741

Loc Oty Loc Code 108 107 Each 95.0000

AN3-4A

Location Loc Qty Loc Code ST351 45 104746 120910 15 30 ST512 50 123759 50 Each 453.0000

Location Loc Qty Loc Code ST350 318 120308 80 122814 38 124858 200 ST512 135 120770 134 123900

											DC	(A:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORI	MANCE / UP	DATE				
 											QA Close	ed:	Date:	;
Work Ord	oř.					DISPOSITION				AGAINST DE	PARTME	NT/PR	OCESS	
WOIK OIG	٠, .					Rework	7		Skid-tube	Crosstube	1	٧	Water Jet	Engineering
Part I	No.					Scrap	1		Machining	Small Fab	f .		ng. Coor.	Quality
	•					Use-as-is	1		noforming	Finishing	-1		ackaging	Other
NCR I	No.	•				Work Order Update]		Large Fab	Composite]	÷	Supplier	
Root			1		Descri	ption of work order update	Т	Initial	Act	tion	Sign &			
Cause		Date Step Qty				or Non-conformance	Ct	nief Eng	Desc	ription	Date		erification	QC Inspector
Doc/Data														
Equip/Tooling														**
Operator												ŀ		
Material			1								· .			
Setup				•	1		1							
Other	_													
Process												ŀ		
Supplier		ļ									-			
Training							1					1		
Unapproved		<u> </u>	İ		<u> </u>									
							AUI	LT CATE	GORY					
Landi	ng (7				General		1			1		_	7_
	<u> </u>	Bending				Bend	\vdash	Grain		_	Ovalized		-	Pressure/Forced
<i>5</i>	<u> </u>	Centre No	ot Concer	ntric to	o/s	BOM/Route	—	Hardwa		ļ	Over/Und		rance	Temperature/Cure
	<u> </u>	Cracks			<u> </u>	Broken/Damaged	\vdash	-l `	ion Incomplete		Part Inco		<u> </u>	Weld
	<u> </u>	Crushed/	Crimped		<u> </u>	Burrs		4	ions Incomplete/	Unclear	Part Lost,		g	Wrong Stock Pulled
		Cuffs			_	Contamination	<u></u>	Mainte		<u> </u>	Part Mov			
l		Heat Trea	it			Countersink	<u></u>	Mislabe	eled	<u> </u>	Positione			7
		Inspectio	n Strip in	Tube		Cut Too Short	1	Misread	t		Power Lo	ss/Surg	e	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

April-16-13 12:35:46 PM

Work Order ID: 99935

99935

646 4001

Parent Item:

646.4001

Parent Item Name: AS350 Cable Cutter

Start Date: 4/16/13 Start Oty: 1.00

Required Date: 4/30/13

Cherry Rivet

CR3213-5-3

Purchased No Each

300.0000

Required Qty: 1.00

MS20470AD5-5.5

Purchased

123785

Location

ST329

Location

Loc Qty 300 Loc Code

300

Each 741.0000

Manufactured

ST336

No

Loc Qty 741 741

Each

2.0000

Loc Code

Loc Code

646.3711

Manufactured No Location ST139B

125083

125083

123425

Loc Oty

2

2

2 Each

2.0000

Location ST139B

Loc Qty

Loc Code

April-16-13 12:35:46 PM

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Page 6

										DQA:	Date:	
NCR: Y	es / No				WORK ORDER NON-C	COP	VFORI	MANCE / UPDAT				
										QA Closed:	Date:	
Work Orde	a i .				DISPOSITION				AGAINST DEI	PARTMENT	/PROCESS	
WOIR Old	-1.				Rework]		Skid-tube C	rosstube		Water Jet	Engineering
Part N	lo.			*.	Scrap	1		—	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is	1 1		~ 	Finishing		re/Packaging	Other
NCR N	lo.				Work Order Update	1		~ —	omposite		Supplier	
						•						
Root				Descri	ption of work order update		nitial	Action		Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Description	on	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator											i e	
Material				, ,								
Setup												
Other												
Process					•							
Supplier		1										
Training												
Unapproved			<u> </u>									<u> </u>
						AUL	T CATE	GORY				
Landi	ng Gear			_	General		ı		 		Γ	
	Bending			ļ	Bend	Ш	Grain		<u> </u>	Ovalized	ļ	Pressure/Forced
•		ot Conce	ntric to	o/s	BOM/Route		Hardwa			Over/Under	· · ·	Temperature/Cure
	Cracks				Broken/Damaged	}		on Incomplete	⊢ ⊣	Part Incorrec	<u> </u>	Weld
		/Crimped			Burrs	-		ions Incomplete/Uncle	—	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination	\vdash	Mainte		1	Part Moved		
	Heat Tre	at		1	Countersink	1	Mislabe	led	1 1	Positioned W	/rong	

Misread

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Cut Too Short Drill Holes

Drawing

Finish

Folio

Power Loss/Surge

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

April-16-13 12:35:46 PM

Work Order ID: 199935

Parent Item:

646,4001

99935

Parent Item Name: AS350 Cable Cutter

646 4001

646.3811

Manufactured

Each 29.0000

Start Qty: 1.00

Start Date: 4/16/13

Required Date: 4/30/13

Required Qty: 1.00

AN3-6A Bolt

MS24694-S55

Purchased No

Purchased

No

Location Loc Qty ST139A 29 125083 9 93224 20 Each

Loc Code

438.0000

Location	<u>n</u>	<u>L</u>	oc Qty	Loc Code
ST350			300	
	124296		300	
ST351			61	
	117441		34	
	121166		13	
	122993		10	
	123831		4	
ST512			77	
	122814		77 .	
		• •	Each	92.0000

Location Loc Oty Loc Code ST303 92 124296 92

April-16-13 12:35:46 PM

Shop Packet Print

Page 7

												DQA:	Da	ate:	
NCR: Y	'es /	No				WORK ORDER NON-C	10:	NFORM	MANCE / UP	DATE		•	·		
												QA Closed:	D:	ate:	
Work Orde	s ř.					DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
WOIK OIGE						Rework			Skid-tube	Crosstube		7	Water Jet	t T	Engineering
Part N	lo.					Scrap			Machining	Small Fab		Pro	d. Eng. Coor	-	Quality
						Use-as-is			noforming	Finishing		-1	e/Packaging		Other
NCR N	lo					Work Order Update			Large Fab	Composite			Supplier	Γ	
	-		- 1		Docario	ntion of work and an wordsta		Initial	Λ α	tion		Sign 9			
Root		. .	Chan	04.		ption of work order update or Non-conformance		1				Sign &	Verification	\n	QC Inspector
Cause	Dia Dia	te !	Step	Qty		or ivon-conformance	C	nief Eng	Desci	ription		Date	vernicatio	711	QC Inspector
Doc/Data		l													
Equip/Tooling	_								:						
Operator	_		1												
Material -		ł													
Setup	-														
Other		ļ													
Process															
Supplier Training						•				•					
Unapproved	\dashv														
Onapproved	<u> </u>		I			· F/	L AUL	T CATE	GORY		-	<u></u>			1
Landii	ng Gear					General									
	Bend	ling				Bend		Grain		ſ		Ovalized			Pressure/Forced
	Cent	re Not (Concen	tric to	o/s 🗀	BOM/Route		Hardwa	re			Over/Under	tolerance		Temperature/Cure
Cracks						Broken/Damaged		Inspecti	on Incomplete	Ţ		Part Incorrec	:t		Weld
Crushed/Crimped						Burrs		Instruct	ions Incomplete/l	Unclear		Part Lost/Mi	ssing		Wrong Stock Pulled
Cuffs						Contamination		Mainte	nance	ļ		Part Moved			•
**	Heat Treat					Countersink	Γ	Mislabe	led	ļ		Positioned W	/rong		
-	Heat Treat Inspection Strip in Tube					Cut Too Short		Misread	1			Power Loss/S	_		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

April-16-13 12:35:46 PM

Work Order ID: 199935

99935

Parent Item:

646.4001

646 4001

Location

125083

ST139A

Parent Item Name: AS350 Cable Cutter

Start Date: 4/16/13 Start Qty: 1.00

Required Date: 4/30/13 Required Qty: 1.00

18.0000

646.3610

646.3714

Gusset

MS20470AD5-6

Purchased

Manufactured

Manufactured

No

Location ST139A

93175

125083

93434

Loc Qty 2 2

Loc Qty

Loc Qty

Each

Loc Oty

7

7

11

11

Each

Each

1,756.000

Loc Code

Loc Code

Loc Code

Loc Code

2.0000

646.3812

Manufactured No ST336

Location

Location

ST139B

93185

1756 866 890 Each 9.0000

**

99657

April-16-13 12:35:46 PM

										DQA:	Da	te:	
NCR: Y	es / No				WORK ORDER NON-C	100	NFOR	MANCE / UPDATE		QA Closed:	Da	te:	
Work Orde	ı.				DISPOSITION			AGAINS	T DE	PARTMENT	/PROCESS		
Work Orde	···				Rework	}		Skid-tube Crosstub		7	Water Jet	Fn	gineering
Part N	lo.				Scrap			Machining Small Fa	-	Pro	d. Eng. Coor.	-	Quality
. 5					Use-as-is	1		noforming Finishin	g	Rec/Sto	re/Packaging		Other
NCR N	lo				Work Order Update]		Large Fab Composit	e]	Supplier		
·		٠.	1			لے				,			
Root				1	ption of work order update	ı	nitial	Action		Sign &			
Cause	Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Description		Date	Verification	n (QC Inspector
Doc/Data	_												
Equip/Tooling													
Operator													
Material												Ì	
Setup													
Other		1						·					
Process					•								
Supplier											·		
Training		1									,		•
Unapproved				<u> </u>						<u> </u>			
٠					F/	AUL	T CATE	GORY					
Landir	ng Gear				General	_			_	7			
	Bending				Bend		Grain		\vdash	Ovalized	,	_	sure/Forced
	Centre No	ot Concer	ntric to	O/S	BOM/Route		Hardwa	re	\perp	Over/Under	tolerance		perature/Cure
	Cracks				Broken/Damaged		Inspecti	on Incomplete	L	Part Incorred		Weld	•
	Crushed/	Crimped			Burrs		4	ions Incomplete/Unclear	L	Part Lost/Mi	ssing	Wro	ng Stock Pulled
	Cuffs				Contamination		Mainte	enance		Part Moved			•
	Heat Treat				Countersink		Mislabe	eled		Positioned V	Vrong		

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Cut Too Short Drill Holes

Drawing

Finish Folio Other

Power Loss/Surge

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

April-16-13 12:35:46 PM

Work Order 1D: 99935

Parent Item:

646.4001

99935 *646 4001*

Location

ST139d

No

Parent Item Name: AS350 Cable Cutter

Start Date: 4/16/13 Start Qty: 1.00

Required Date: 4/30/13 Required Qty: 1.00

268.0000

Loc Code

5.0000

Loc Code

Bolt

AN3-3A

646.3813

MS20470AD5-7

MS21047-3

Manufactured

Purchased

Location Loc Qty ST350 268 123831 7 124221 200 124552 61 Each

Each

Purchased No

Purchased

No

5 125083 5 Each

Loc Qty

2,194.000

**

Loc Code

Location Loc Qty Loc Code Mezz 1384 2655 799 3011 585 ST336 810 123425 810 Each 445.0000

NUT PLATE

Location Loc Oty ST316 445 123268 75 123301 50 123522 320

NCR:	Yes	1	No
IVCIV.	163	1	140

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: ____

NCK: Y	es / No				WORK ORDER NON-C	JOINTC	JRIVIAINCE /	UPDATE		QA Closed:	Dat	te:
Work Orde	ir.				DISPOSITION			AGA	INST DE	PARTMENT	/PROCESS	
					Rework]	Skid-tube Machining		tube	Pro	Water Jet d. Eng. Coor.	Engineering Quality
Part N	10.				Scrap Use-as-is		iviacining		shing		re/Packaging	Other
NCR N	lo	·			Work Order Update	·	Large Fab		· ·	Rec/Stoi	Supplier	
Root				Descri	ption of work order update	Initia	al	Action		Sign &		
Cause	Date				or Non-conformance	Chief E	ng	Description		Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling			٠.			1					•	• ,
Operator												
Material												
Setup							1				i	
Other												
Process												
Supplier												·
Training		ļ										
Unapproved												
					F.	AULT CA	ATEGORY					
Landin	ng Gear			_	General					ì	-	_
1	Bending				Bend	Gra			<u> </u>	Ovalized	1	Pressure/Forced
	Centre No	ot Concer	ntric to	o/s	BOM/Route	\mathbf{H}	dware			Over/Under	<u> </u>	Temperature/Cure
	Cracks			<u>_</u>	Broken/Damaged		ection Incompl		_ ⊢	Part Incorred) -	Weld
	Crushed/	Crimped			Burrs		ructions Incom	olete/Unclear	<u> </u>	Part Lost/Mi	ssing [Wrong Stock Pulled
					Contamination		intenance		<u> </u>	Part Moved		
Heat Treat					Countersink	$\boldsymbol{\vdash}$	labeled			Positioned V		
1	Inspectio		Tube		Cut Too Short	⊢ −−	read		L	Power Loss/	Surge [Other
ļ	Ripples in				Drill Holes	Offs						
	Torque W			n	Drawing	\vdash	of Calibration			***		· · · · · · -
	Turning S	-			Finish	 	of Sequence					····
	Wave/Tw	ist in Tub	эе		Folio	Out	side Dimension	S				

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

April-16-13 12:35:46 PM

Work Order ID: 99935

Parent Item:

CCR264SS3-02

646.4001

Parent Item Name: AS350 Cable Cutter

99935 *646 4001*

No

Start Date: 4/16/13

Start Qty: 1.00

740.0000

Loc Code

Required Date: 4/30/13

Required Qty: 1.00

AN3-5A

646.3715

Strut Doubler

Purchased No

Purchased

Location Loc Qty ST327 740 106578 100 123785 240 124231 200 124259 200

Each 1,103.000

Each

Manufactured

No

Location Loc Oty Loc Code FP001 86 122800 86 GA 120 117423 120 ST350 22 120187 22 ST512 875 122416 75 124561 800

Each

12.0000 **

Location Loc Qty Loc Code ST139B 12 93338 12

				DQA:	Date:
NCR:	Yes /	No	WORK ORDER NON-CONFORMANCE / UPDATE		
				QA Closed:	Date:

											QA Closed	: Da	te:	
Work Orde	er: _					DISPOSITION				AGAINST DI	EPARTMENT			
Part N						Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	-1	Water Jet od. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Root	\neg				Descri	ption of work order update		nitial	Ac	tion	Sign &			
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	n -	QC Inspector
Doc/Data	Ţ													
Equip/Tooling														
Operator [1							
Material														
Setup							l							,
Other														
Process														
Supplier														
Training														
Unapproved							L		<u> </u>			<u> </u>		
***************************************							AUL	T CATE	GORY					· · · · · · · · · · · · · · · · · · ·
Landir					_	General	_	1		_	7	1		l_
	-	Bending			.	Bend	<u> </u>	Grain		_	Ovalized		-	Pressure/Forced
	\vdash	Centre No	t Concer	ntric to	o/s	BOM/Route	<u> </u>	Hardwa		-	Over/Unde		-	Temperature/Cure
	-	Cracks		•	-	Broken/Damaged	<u> </u>	4 .	on Incomplete	-	Part Incorre			Weld
	_	Crushed/0	Crimped		<u> </u>	Burrs	\vdash	4	ions Incomplete/	Unclear	Part Lost/M			Wrong Stock Pulled
	Cuffs Contamination				╡	\vdash	Mainte			Part Moved				
	Heat Treat Countersink					<u> </u>	Mislabe		<u> </u>	Positioned	· ·		Other	
	Inspection Strip in Tube Cut Too Short					\vdash	Misread	ג	L	Power Loss	rourge		Other	
	▶ 				Drill Holes		Offset	Salibaatiaa						
					Drawing	<u> </u>	-	Calibration						
	├					Finish	-	4	Sequence					
	II\	Wave/Twist in Tube Folio						Outside	Dimensions					

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Work Order ID: 99935

646.4001

99935

Parent Item Name: AS350 Cable Cutter

Parent Item:

646 4001

Start Date: 4/16/13

Required Date: 4/30/13

Start Qty: 1.00

Required Oty: 1.00

MS27039-1-12

646.3716

Gauge Bracket

MS20426AD5-7

MS24694-S54

Purchased

Manufactured

Purchased

Purchased

No

No

No

Location

125083

Location Mezz

100993

125083

Loc Qty 169 169

Each

4.0000

169.0000

Loc Code

Loc Qty Loc Code

Each

Each

813.0000

Location Loc Qty Loc Code ST334 813

101340

813 Each

75

76.0000

Location Loc Oty ST303 76

123900 124859

Loc Code

												DQA:	D	ate:	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UP	DATE					
		•							•			QA Closed:	D	ate:	
Work Ord	er.					DISPOSITION				AGAINST D	EF	PARTMENT	/PROCESS		
WOIK OIG	٠					Rework	7		Skid-tube	Crosstube	٦		Water Je	t	Engineering
Part !	No.					Scrap	1 1	1	Machining	Small Fab	1	Pro	d. Eng. Coor		Quality
	•					Use-as-is]	Therm	noforming	Finishing		Rec/Stor	e/Packagin	<u> </u>	Other
· NCR I	۷o.					Work Order Update]		Large Fab	Composite			Supplie	r[
			T		- Danasi		т.	la iki al	A		_	Cian 9			<u> </u>
Root			١.,	١		ption of work order update		Initial		tion	١	Sign &	Vifi4i		06 In an a star
Cause		Date	Step	Qty	•	or Non-conformance	Cr	nief Eng	Desc	ription	+	Date	Verification	<u>m</u>	QC Inspector
Doc/Data	Н										1				
Equip/Tooling											١				
Operator	Ш						1				١				
Material											Ì				
Setup	Ш			İ			-				1		•		
Other											1	,			
Process	Щ						İ								
Supplier	Ш						i				1				
Training											1				
Unapproved			<u> </u>								_		1		
						F	AUI	LT CATE	GORY						
Landi	ng (Gear				General		.		_	_			,	•
		Bending			L	Bend		Grain			┙	Ovalized		L	Pressure/Forced
		Centre N	ot Conce	ntric to	o/s	BOM/Route	L	Hardwa	re	L	╛	Over/Under	tolerance	L	Temperature/Cure
,		Cracks				Broken/Damaged		Inspecti	on Incomplete		╛	Part Incorred	it .	L	Weld
Crushed/Crimped						Burrs		Instruct	ions Incomplete/	Unclear	\rfloor	Part Lost/Mi	ssing	L	Wrong Stock Pulled
1		Cuffs				Contamination		Mainte	enance	[bracket	Part Moved			
		Heat Trea	at			Countersink		Mislabe	eled		٦	Positioned W	/rong		_
	Inspection Strip in Tube Cut Too Short								i		7	Power Loss/S	Surge		Other

Offset

Out of Calibration
Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

April-16-13 12:35:46 PM

Work Order ID: 99935

Parent Item:

MS27039-1-21

646,4001

Parent Item Name: AS350 Cable Cutter

99935

646 4001

Start Date: 4/16/13

Required Date: 4/30/13

Start Oty: 1.00

Required Qty: 1.00

343.0000

MS27039-1-20

MS27039-1-19

Purchased

Purchased

Purchased

Manufactured

No

No

No

Location

Location

ST306

ST506

st510

Location

ST306 115935 ST506

124326

124326

122814

123522

124326

125083

300 Each

43

43

300

Loc Qty

Loc Qty

Loc Qty

102

100

746

746

2

2

Each

2

478

Each

478.0000

Loc Code

Loc Code

478 Each

848.0000

Loc Code

Location ST139B

Loc Oty

Loc Code

2.0000

Sper

NCR: Y	•															
													QA Closed:	Dat	te:	
Work Orde	r: _						DISPOSITION					_	PARTMENT			
Part N	lo						Rework Scrap		ſ	Skid-tube Machining noforming	Crosstube Small Fab Finishing			Water Jet d. Eng. Coor. e/Packaging		Engineering Quality Other
NCR N	lo	· · · · · · · · · · · · · · · · · · ·					Use-as-is Work Order Update]	1	Large Fab	Composite	\vdash	Rec/Stor	Supplier		Other
Root					Des	crip	otion of work order update		Initial	Act	ion		Sign &			
Cause		Date	Step	Qty		O	r Non-conformance	Ch	nief Eng	Descr	iption		Date	Verification	n	QC Inspector
loc/Data quip/Tooling	\dashv				,											
perator	7															
/laterial																
etup																
ther																·
rocess					,											
upplier						•										
raining																
Iṇapproved																
							F	AUL	T CATE	GORY					•	
Landi	ng Ge	ear					General						•			•
	В	Bending			į		Bend		Grain				Ovalized	ļ		Pressure/Forced
	c	entre No	t Concer	ntric to	o/s		BOM/Route	L	Hardwa	re		L	Over/Under	t t		Temperature/Cure
	Cracks						Broken/Damaged	L	4 '	on Incomplete		_	Part Incorred	it		Weld
	c	Crushed/Crimped Burrs					Burrs	L	Instruct	ons Incomplete/U	Inclear		Part Lost/Mi	ssing		Wrong Stock Pulled
	Cuffs						Contamination ·	L	Mainte	nance		<u> </u>	Part Moved			
	Heat Treat						Countersink		Mislabe				Positioned W	_ ,		,
	inspection Strip in Tube						Cut Too Short		Misread				Power Loss/	Surge		Other
	R	Ripples in	Bend				Drill Holes	L	Offset		•					
:	╝	orque W	aves in E	extrusio	n		Drawing	Ŀ	Out of C	Calibration						
	lτ	urning Se	eauence				Finish		Out of S	eguence						i

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

Folio

April-16-13 12:35:46 PM

Work Order ID: 99935

Parent Item: 646,4001 *99935* *646 4001*

Location

ST139A

ST522

Parent Item Name: AS350 Cable Cutter

646.3719

MS27039-1-10

Screw

646.3718

Manufactured

No

Start Date: 4/16/13 Start Qty: 1.00

45.0000

Loc Code

24.0000

**

**

Required Date: 4/30/13

Required Qty: 1.00

Manufactured

Purchased

Location ST139B

ST506

125083

125083

Loc Qty 24 24

Each

38 38

Each

Each

Loc Oty

321.0000

Loc Code

120083

Location Loc Oty GA 100 120449 100 ST305 101 122815 124859 100 ST308 18

123522 18 102 124326 102 Loc Code

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-	CONFO	RMANC	E / UP	DATE	046	D-4	
,											QA Closed:	Date:	
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N	- _ No.					Rework Scrap Use-as-is Work Order Update	The	Skid-tu Machini ermoformi Large F	ng	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	Initial		Act	tion	Sign &		
Cause		Date	Step	Qty	C	or Non-conformance	Chief Er	ng	Desc	ription	Date	Verification	QC Inspector
Doc/Data									•				
Equip/Tooling	Ш						İ						
Operator	Ш												
Material	Ц												
Setup	Ш												
Other	Ш											٠.	
Process	Ш												
Supplier	Ш									,			
Training	Ш						1						
Unapproved	Ш									:			
					······································		AULT CA	TEGORY					
Landi		1				General					1	-	1
*	1 1	Bending				Bend	Grain	n			Ovalized		Pressure/Forced

Hardware

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Inspection Incomplete

Instructions Incomplete/Unclear

Temperature/Cure

Wrong Stock Pulled

Weld

Other

Over/Under tolerance

Part Incorrect

Part Moved

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

BOM/Route

Contamination Countersink

Cut Too Short Drill Holes

Drawing

Finish

Folio

Burrs

Broken/Damaged

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Cracks

Cuffs

Heat Treat

Crushed/Crimped

Inspection Strip in Tube

Torque Waves in Extrusion

Centre Not Concentric to O/S

April-16-13 12:35:46 PM

Work Order ID: 99935

Parent Item:

AN3-11A

600.0990

600.0991

600.1012

646,4001

Parent Item Name: AS350 Cable Cutter

99935 *646 4001*

No

Start Date: 4/16/13

Start Qty: 1.00

672.0000

Required Date: 4/30/13

Required Qty: 1.00

56

Purchased

Purchased

No

Location Loc Qty Loc Code ST351 72 123525 72 ST512 600 115457 100 123352 200

Each

123759 300 Each

9.0000

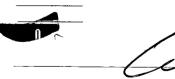


Purchased No Location Loc Qty Loc Code ST 125051 Each 9.0000



Purchased No Location Loc Qty Loc Code ST 125051 9 Each

9.0000 **



**

Location Loc Oty Loc Code ST

125051

9

25051

NCR:	Yes	/	No

DQA: ____ Date: ____

NCR: Y	\cdot										
				-					QA Closed:	Date:	
Work Order: DISPOSITION								AGAINST DI	PARTMENT	/PROCESS	
					Rework	7	Skid-tube	Crosstube]	Water Jet	Engineering
Part N	0.				Scrap	1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
			Use-as-is	Th	ermoforming	Finishing	Rec/Sto	re/Packaging	Other		
NCR No.			Work Order Update]	Large Fab	Composite	•	Supplier]		
		T							1	·	1
Root		1			iption of work order update	Initia	1	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief E	ng Desc	ription	Date	Verification	QC Inspector
Doc/Data											
quip/Tooling				;							
Operator						ŀ					
Material	_										
Setup											
Other Process		1				1					
Supplier											
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1		1			F	AULT CA	TEGORY		.1		
Landir	ng Gear				General					* ***	
ſ	Bending				Bend	Gra	in		Ovalized		Pressure/Forced
Ī	Centre No	ot Conce	ntric to	o/s	BOM/Route	Hare	lware		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Insp	ection Incomplete		Part Incorred	it	Weld .
٠. [Crushed/	Crimped			Burrs	Inst	uctions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
Ī	Cuffs				Contamination	Mai	ntenance		Part Moved		
	Heat Trea	at _.			Countersink	Mis	abeled		Positioned V	Vrong	_
	Inspection	n Strip in	Tube		Cut Too Short	Mis	ead		Power Loss/	Surge	Other
	Ripples in	Bend			Drill Holes	Offs	et				
	Torque W	/aves in E	xtrusio	1 [Drawing	Out	of Calibration				
	Turning S	equence		· [Finish	Out	of Sequence				
	Wave/Tw	ist in Tul	oe .		Folio	Out	side Dimensions				

April-16-13 12:35:46 PM

Work Order ID: -99935

646.4001

Parent Item Name: AS350 Cable Cutter

99935 *646 4001*

Start Date: 4/16/13

Start Qty: 1.00

Required Date: 4/30/13

Required Qty: 1.00

600.0129

Parent Item:

600.1013

646.3910

646.3911

646-3911 Shim

Purchased

Purchased

Manufactured

Manufactured

No

No

Location ST

Location

ST139A

Location

ST139B

125031

125154

125083

Loc Qty 128 128

Each

945.0000

Loc Code

128.0000

**

Loc Qty Loc Code

945 945

Each 72.0000

Loc Qty Loc Code

22

ST139d

22

50 50

19

19

Each

20.0000

**

25154

Location Loc Oty ST139A 125083

ST139d

93362

Loc Code

												DQA:	Date	
NCR: Y	CR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE													
	QA Closed: Date:													
Work Orde	er:						DISPOSITION				AGAINST DI	EPARTMENT	/PROCESS	
Part No.					Rework Scrap Use-as-is		ľ (Skid-tube Crosstube Small Fab Thermoforming Finishing		Water Jet Prod. Eng. Coor. Rec/Store/Packaging		Engineering Quality Other		
NCR N	۱o. ₋		· . — —			İ	Work Order Update			Large Fab	Composite	_	Supplier	
Root	· [Des	crip	ntion of work order update	T	Initial	Ac	ction	Sign &		;
Cause		Date	Step	Qty		С	r Non-conformance	CI	nief Eng	Desc	cription	Date	Verification	QC Inspector
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	_	Bending					Bend	Г	Grain			Ovalized		Pressure/Forced
	-	Centre No	ot Concei	ntric to (o/s		BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	-	Cracks			-,-		Broken/Damaged		4	ion Incomplete	-	Part Incorred	⊢	Weld
- 7	-	Crushed/	Crimped				Burrs		⊣ '	ions Incomplete/	/Unclear	Part Lost/Mi	 	Wrong Stock Pulled
		Cuffs	-				Contamination		Mainte	•		Part Moved	· _	
	-	Heat Trea	ıt				Countersink		Mislabe			Positioned V	Vrong	
	\vdash	Inspection		Tube			Cut Too Short		Misread	i		Power Loss/	Surge	Other
	—	Ripples in	-				Drill Holes		Offset			_		
		Torque W		Extrusio	n		Drawing	Ţ.	Out of 0	Calibration				
	Н	Turning S			-		Finish		Out of	Seauence				

Outside Dimensions

Wave/Twist in Tube

Folio

April-16-13 12:35:46 PM

Work Order ID: 299935

Parent Item:

646.4001

99935 *646 4001*

Location

Parent Item Name: AS350 Cable Cutter

646.3912

Manufactured

Start Qty: 1.00 Each 73.0000

Loc Code

**

Start Date: 4/16/13

Required Date: 4/30/13

Required Qty: 1.00

Manufactured No

ST139A 125083 ST139d

22 22 51 51 Each 36.0000

Loc Oty

646.3913

AN3-12A

Purchased No

Location Loc Oty Loc Code ST139B 16 16 ST139d 20 93160 20 Each 59.0000

25083

Location Loc Oty Loc Code GA 122407 6 ST351 114536 123352 ST512 48

48

23759

123759

									DQA:	Date:	•
NCR: Y	es / No			WORK ORDER NO	WORK ORDER NON-CONFORMANCE / UPDATE					Date:	
Work Orde	er:			DISPOSITION				AGAINST DEI	PARTMENT	/PROCESS	
Part No			Scrap Use-as-is	Scrap Machining Small Fa Use-as-is Thermoforming Finishir		Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other		
Root				Description of work order updat	e In	itial	Ac	tion	Sign &		
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etup								İ			
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	Cracks	Broken/Damaged	Inspection Incomplete	Part Incorrect	Weld
	Crushed/Crimped	Burrs	Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled
	Cuffs	Contamination	Maintenance	Part Moved	•
	Heat Treat	Countersink	Mislabeled	Positioned Wrong	 _
	Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge	Other
. [Ripples in Bend	Drill Holes	Offset		
	Torque Waves in Extrusion	Drawing	Out of Calibration		
Γ	Turning Sequence	Finish	Out of Sequence	`	
	Wave/Twist in Tube	Folio	Outside Dimensions		

FAULT CATEGORY

Process
Supplier
Training
Unapproved

April-16-13 12:35:46 PM

Work Order ID: \. 99935 \.

Parent Item:

646.4001

Parent Item Name: AS350 Cable Cutter

99935 *646 4001*

> **Start Date:** 4/16/13 Start Qty: 1.00

Required Date: 4/30/13

Required Qty: 1.00

MS27039-1-16

Purchased

No

Each 70.0000

**

Location Loc Qty Loc Code ST306 70 122993 70

April-16-13 12:35:46 PM

Shop Packet Print

Page 17

										DQA	: Date	:
NCR: Y	es / No)			WORK ORDER NON-	WORK ORDER NON-CONFORMANCE / UPDATE						•
,										QA Closed	: Date	:
Work Orde	ir-				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
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			Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other		
NCR N	lo				Work Order Update]		Large Fab	Composite]	Supplier	
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Offset

Out of Calibration
Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

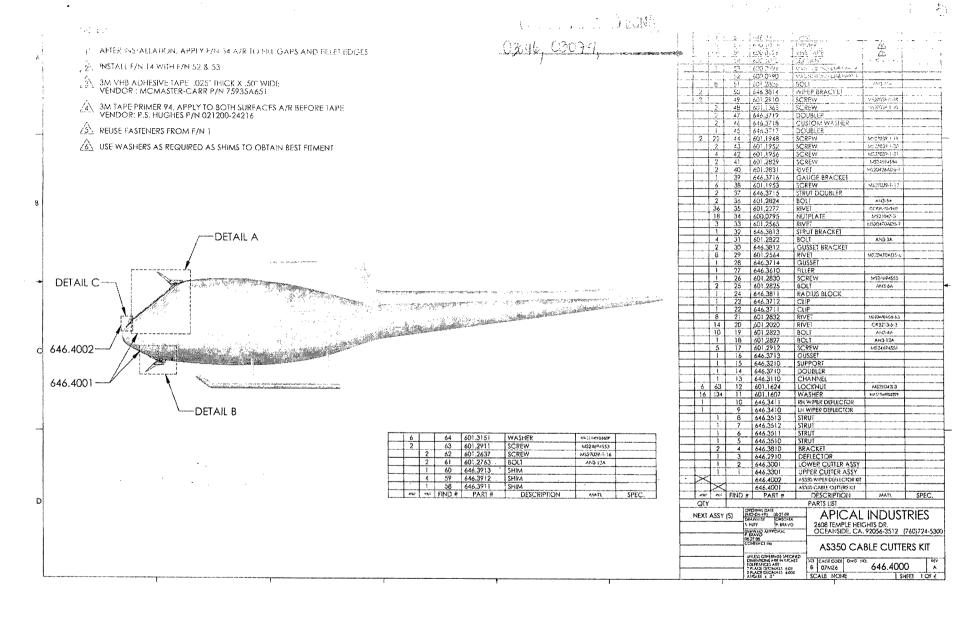
Drawing

Finish Folio

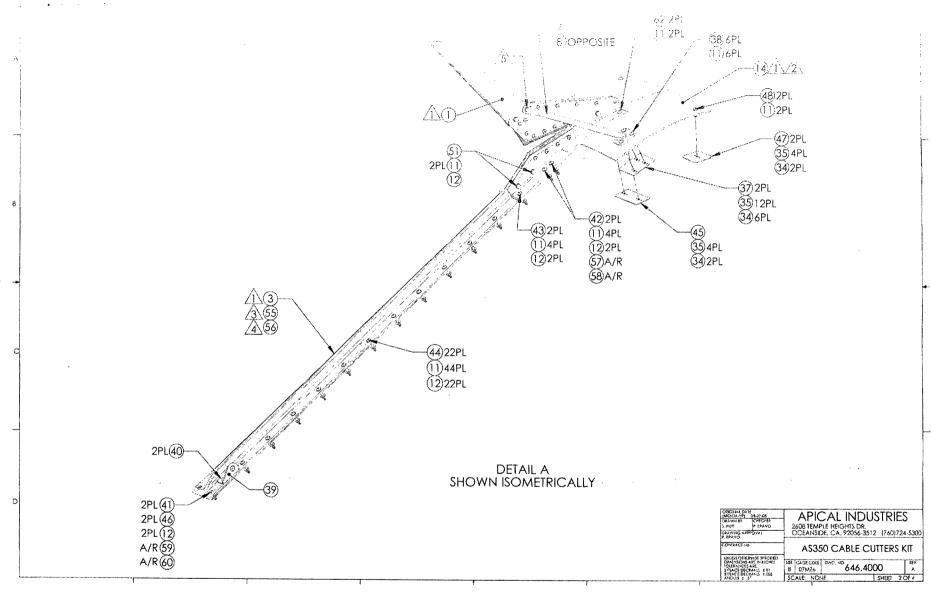
ENGINEERING CHANGE NOTICE NO 33079 SHEET I JF 3 DWG NO. 646.4000 REV: A PREVIOUS NICAP DATE 03/21/11 EFFECT ON DWG INDUSTRIES, INC. DWG TITLE: AS350 CABLE CUTTERS KIT APPROVED BY DIRECT OF DIRECT DESCRIPTION OF STATE OF STAT										
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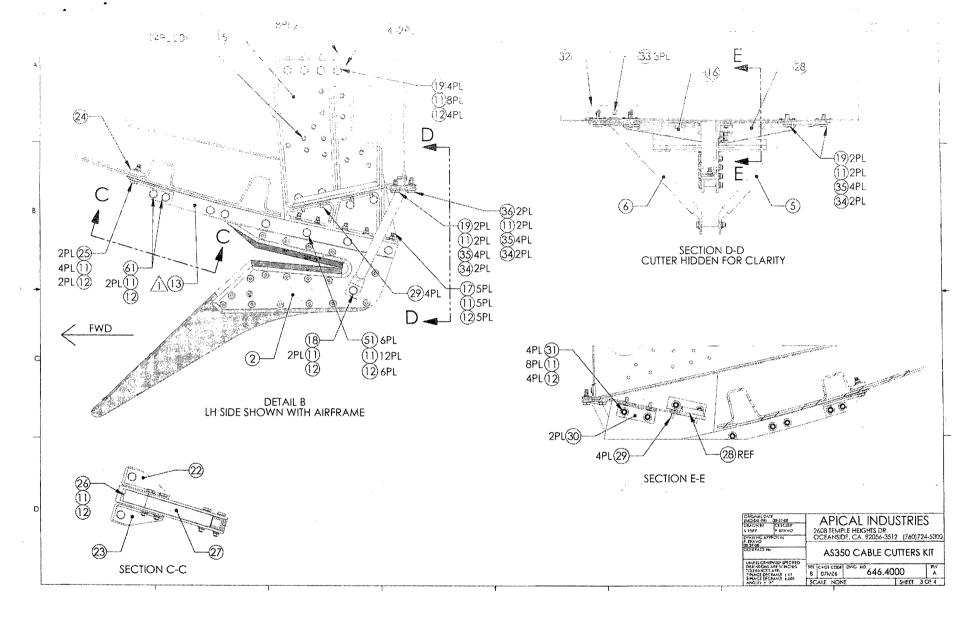
ENGINEERING CHANGE NOTICE NO. 03046 SHEFT 1 EFFECT ON DWG OINC. PREPARED J. JACKSON DATE: 01/24/11 REV: A DWG NO. 646.4000 DWG TITLE: AS350 CABLE CUTTERS KIT INDUSTRIES, INC. APPROVED BY: ENGR Brance NEXT ORDER TRANSACTION CODES (TC): A-ADD C-CREATE REASON: ADDÉD GPS MOUNT KIT, F/N 65. REVISED DRAWING VIEWS ADDED NOTE /7 D-DELETE R-REVISE SHEET 1, ZONE B1 IS: AT CUSTOMERS OPTION, INSTALL F/N 65 BY MATCH DRILLING ONTO F/N 1. SHEET 2, ZONE B2 IS: SHEET 2, ZONE A4 IS: (8)OPPOSITE DETAIL D REF (1) DETAIL D
TYPICAL GPS MOUNT KIT INSTALLATION 647.5701 REF GPS MOUNT KIT 65 A .4001 FINITC PART NUMBER MATERIAL SPECIFICATION. CHANGE CATEGORY

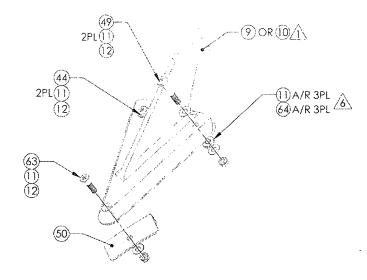
☐ MDL ☐ INSTALL INSTRUC ☐ ICA ☒ BOM ☐ MAJOR ☒ MINOR DER REVIEW REQUIRED DOCUMENTS EFFECTED: ☐ YES ⊠ N□



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DETAIL C LH SHOWN EXPLODED RH OPPOSITE

APICAL INDUSTRIES

APICAL INDUSTRIES

2608 TEMPLE HEIGHTS CR.

CCEANSIDE, CA. 92056-3512 (750)724-3300

AS350 CABLE CUTTERS KII

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Item 1D: 646.4001 Revision 1D: Accept Item Name: AS350 Cable Cutter Start Date: 4/16/13 Start Qty: 1.00 *1* Required Date: 4/30/13 Req'd Qty: 1.00 *1* Reference: Approvals: Process Plan: MLJ Date: 13-04-16 Tooling: QC: Date: SPC (Y/N): Sequence ID/ Operation Work Center ID Set Up/ Description Run Hours Draw Nbr **Revision Nbr** 646.4000 Α 100 *100* 0.00 DOCUMENT CONTROL · Memo Document Control 0.00 Photocopy bluefile & type labels per PPP 646.4001 110 Pick Kit *110* 0.00 Packaging Memo Packaging 0.00 120 QC4-100% Inspect kits for completeness *120* 0.00 Memo Quality Control 0.00

N900040100 Setup Start Cust Item 1D: Customer: Run Start Date: Stop Date: Tool ID Tool # Plan Accept Reject Reject Insp. Code Qty Qty Number Stamp MLJ 13-04-Z6